



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2892-1

Job Sheet 197732



Part No: D2892-1

Job Qty: 8 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/23/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04
as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	8/23/19	8/23/19	0.36	6.78	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	8 pcs	8/23/19	8/23/19	0.00	0.00	QC 8 - 12		mml 2019/08/08
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		mml 19/08/13
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Crosstubes - 2 - B4B	8 pcs	8/23/19	8/23/19	0.00	1.29	Crosstubes - 1 - B4B		RD 19-8-13

DART
AEROSPACE

Container No: S203970

Part: D2892-1

Job No: 197732

Serial No/Batch: S203970

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Alderdaen Street
Hemel Hempstead, ON K64 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/09/19

140 QC 3	8 pcs	8/23/19	0.00 0.00	Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	8 pcs	8/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

DAS
AUG 14 2019 40
9-89

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	8/23/19	0.00 0.00	QC 21 - SA - 21	QAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59

AUG 15 2019

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA082
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Crosstubes) Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time 3176225
 140 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK077	D2892-1 Turning Detail	4 pcs (.5 ea)	100-HAAS 4 Axis	1x 5038670 3x 5200864

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK077	4	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		

DART AEROSPACE LTD		Work Order:	197732
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.150		.130	.132	.132	.131	.131
AB	0.290	0.310		.292	.294	.295	.291	.296
AC	0.040	0.060	*	.059	.060	.060	.060	.053
AD	0.115	0.150		.127	.126	.126	.126	.125
AE	0.240	0.260		.249	.249	.250	.250	.251
AF	0.188	0.193		.186	.189	.189	.189	.189
AG	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AH	1.116	1.156		1.143	1.144	1.145	1.143	1.142
AI	0.454	0.474		.473	.457	.457	.457	.454
AJ	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AK	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.679	1.677	1.678	1.677	1.679
AN	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AO	0.022	0.042		R.032 ok	R.032 ok	R.032 ok	R.032 ok	R.032 ok
AP	2.779	2.789		2.780	2.782	2.782	2.782	2.787
AQ								
AR								
AS								
AT								
Accept/Reject								

DAS
9-89

Measured by: MM

Date: 2019/04/04

Audited by: mmc

Date: 19/08/13

Preliminary Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	<u>AS</u>

DART AEROSPACE LTD		Work Order:	
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	4	5
HAAS Section								
AA	0.115	0.150		.131	.295	.132 = .133		
AB	0.290	0.310		.295	.299	.299		
AC	0.040	0.060		.052	.054	.054		
AD	0.115	0.150		.125	.127	.127		
AE	0.240	0.260		.250	.251	.251		
AF	0.188	0.193		.189	.189	.189		
AG	0.240	0.260		R.250 ok	R.250 ok	R.250 ok		
AH	1.116	1.156		1.142	1.146	1.147		
AI	0.454	0.474		.455	.465	.465		
AJ	0.240	0.260		R.250 ok	R.250 ok	R.250 ok		
AK	0.053	0.073		R.063 ok	R.063 ok	R.063 ok		
AL	0.257	0.262		.259	.259	.259		
AM	1.663	1.683		1.678	1.678	1.678		
AN	0.053	0.073		R.063 ok	R.063 ok	R.063 ok		
AO	0.022	0.042		R.032 ok	R.032 ok	R.032 ok		
AP	2.779	2.789		2.783	2.783	2.783		
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>M.M.</i>	4 64	Date:	<i>2019/08/08</i>
Audited by:	<i>mml</i>	89 9-89	Date:	<i>14/08/13</i>
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	<i>[Signature]</i>